

Date: Tuesday, 31/03/2009 1:05:04 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INDEXING BLOCK
Job Number : 46756	
Estimate Number : 13319	
P.O. Number :	Part Number : D37901
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D3790 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 44948	Material :
Written By :	Due Date : 07/04/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JLD 09-03-31</u>	
Comment : Est Rev:A New Issue 08-05-16 JLM Verified By:DD Est Rev:B 09-02-20 rev.b as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNB2000X3000	Delrin Bar 2" x 3"
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Comment: Qty.: 0.5250 f(s)/Unit Total : 3.1500 f(s)

Delrin Bar 2" x 3"

Batch: M108068

5" Scrap

N.A

09/04/02

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 5.900 " long

N.A

09/04/02

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA745 Rev: AA & Dwg D3790 Rev: B

2-Deburr per dwg D3790

09/04/04

09/04/04

(4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/04

09/04/04

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3790-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 09/04/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46756</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/04	3.0.	One part came out of the vise on the first operation. LC. error in program speed not enough fast. feed too fast.	<i>[Signature]</i>	Setup / no replace. Qty 1 - revise to 1.10	<i>[Signature]</i> 09/04/04	J.F. 09/04/06	<i>[Signature]</i>	<i>[Signature]</i>
			<i>[Signature]</i>				<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Tuesday, 31/03/2009 1:05:04 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INDEXING BLOCK

Job Number: 46756

Part Number: D37901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



4K

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B39

9/4/7

SD

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WF
09-04-07

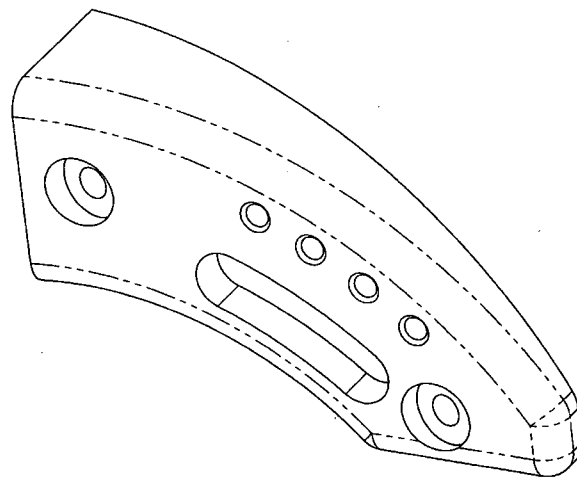
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
09/02/05 MB

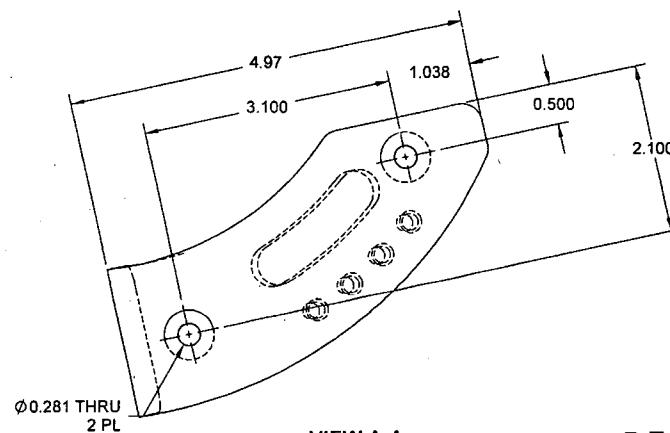
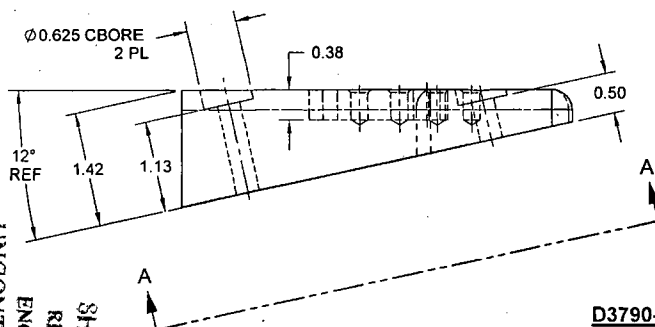
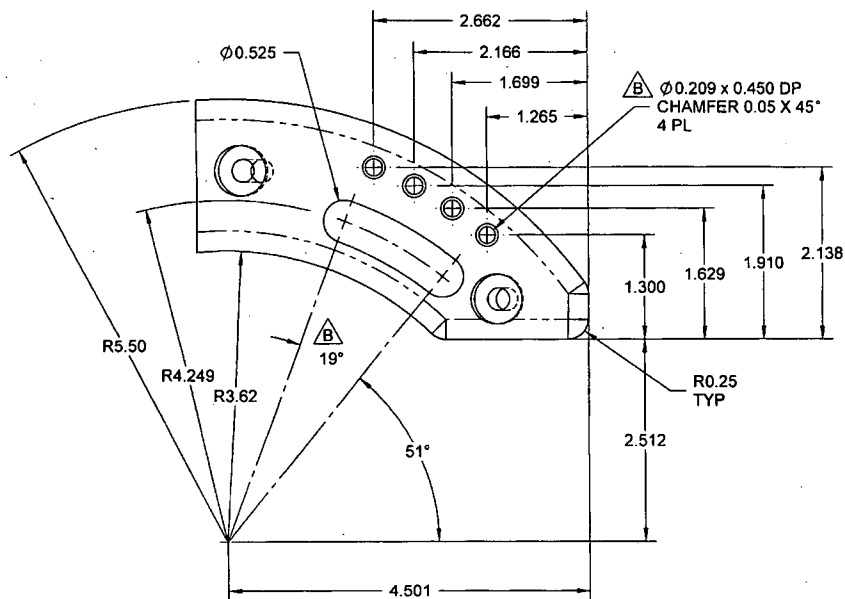
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 146156

D3790-1 INDEXING BLOCK

NOTES:

- 1) MATERIAL: BLACK ACETRON GP ACETAL
(REF DART SPEC M-DELIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3790-1" USING VIBRATING STYLUS
- 7) WEIGHT: 0.39 lbs

B	UPDATED NOTE 1 (ZN A6-1); Ø0.209 WAS Ø0.250 AND 4 PL WAS 5 PL (ZN D5-2); 19" WAS 25" (ZN C7-2). REASON: REDESIGNED TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN D3705-041 AND D3676-1 AT INSTALLATION		MB	08.06.26
A	NEW ISSUE		MB	08.05.13
REV.	DESCRIPTION		BY	DATE
DESIGN	15		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	15		DRAWING NO. REV. B	
CHECKED	Red		D3790 SHEET 1 OF 2	
MFG. APPR.	MM		TITLE SCALE	
APPROVED	MM		INDEXING BLOCK NTS	
DE APPR.	MM		DATE 08.06.26	
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VIEW A-A

RELEASED
09/12/05 MRS

D3790-1 INDEXING BLOCK

NO. 16756
WORK ORDER
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SHOP COPY

DESIGN		DART AEROSPACE LTD	REV. B
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3790	SHEET 2 OF 2
MFG. APPR.		TITLE INDEXING BLOCK	SCALE NTS
APPROVED		DATE 08.06.26	
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 46756
Description: Indexing Block		Part Number: 037901
Inspection Dwg:	Rev: B	Page 1 of 2 Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.209	$\pm .005$ $\pm .001$.209				
0.450	$\pm .010$.440				
.050 x 45°	$\pm .010 \times .5^\circ$.048 x 45°				
1.265	$\pm .010$	1.265				
1.699	$\pm .010$	1.699				
2.166	$\pm .010$	2.166				
2.662	$\pm .010$	2.662				
1.300	$\pm .010$	1.300				
1.629	$\pm .010$	1.629				
1.910	$\pm .010$	1.910				
2.138	$\pm .010$	2.138				
R.0.25	$\pm .030$	R.25				
R 3.62	$\pm .030$	R 3.62				
R 4.249	± .010 $\pm .010$	R 4.249				
R 5.50	$\pm .030$	R 5.50				
19°	$\pm .5^\circ$	19°				
51°	$\pm .5^\circ$	51°				
Ø.525	$\pm .008$ $\pm .001$.526				
Ø.281	$\pm .006$ $\pm .001$.283				
Ø.625	$\pm .008$ $\pm .001$.624				
4.97	± 0.030	4.964				
3.100	$\pm .010$	3.100				
1.038	$\pm .010$	1.038				

Measured by: JS
Date: 09/04/04

Audited by: J.L
Date: 09/04/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

